

5264004



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246



3/13/20
MLC

D5810-15
Job Sheet 207550



POSITIVE RECALL



Part No: D5810-15

Job Qty: 4 pcs

EFFECTIVE DATE: 2/13/20 **AUTH:** MLC

Part Name: Cap

28

RELEASED: _____ **DATE:** _____



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/27/20

Job Tracking No:

Created By: Jennifer Renwick

Due Date: 4/27/20

Description:

Type: Stock

Note: URF 20-522 DWG D5810 Rev A IPP Rev. A 2020.01.30 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	4 pcs	4/27/20	4/27/20	0.17	0.27	Waterjet - Flow		DC 20/03/17
110	QC 2	4 pcs	4/27/20	4/27/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		DC 20/03/17
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		

Plex 3/12/20 8:05 AM Dart.lajeunesse.marie

120 QC 8	4 pcs	4/27/20	0.00 0.00	QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
0.00 0.00				Packaging 3 - 1 - B4B	MFK
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 37 - B4B	
140 QC 21 - SA	4 pcs	4/27/20	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Add Please
Some Packaging 3-6
" 3-7
" 3-8
" 3-9
etc...

DAS
40

MAR 17 2020 9:58

Part Op 100 - 1-Cut as per DWG. DWG. Rev: A PROC. Rev: A 2-Debur if necessary
 Descriptions: 110 - QC2- Inspect parts off machine FA/FAIB
 120 - QC8- Inspect parts - second check
 130 - Identify as per dwg & Stock Location: W/A 004
 140 - QC21- Final Inspection - Work Order Release

MAR 17 2020

Job BOM

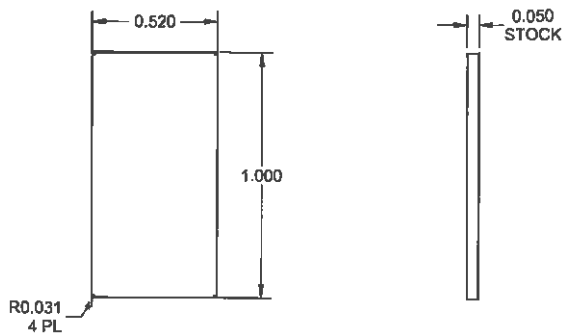
Part / Item	Component Name	Quantity	Operation	Container
M1010S18GA	1010/1025 Sheet .048	.0160 sf (.004 ea)	100-Waterjet - Flow - 1	FM137041-1

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M1010S18GA	0	84	0

Part Specifications

Specifications could not be found.



D5810-15 CAP

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 207550 MWS
2003-12

UNDER REVIEW

URF 2020-522 20.02.14 (NO)

NOTES:

- 1) MATERIAL: AISI 1010/1025 STEEL SHEET, COLD ROLLED, #18 GA (0.050 THICK)
PER ASTM A36/A366/A1008 OR CSA G40-21 38W/44W/50W/60W/70W
REF DART SPEC M1010-S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.01 lbs

RELEASED

2020 FEB 18 No

APPROVED

DESIGN	ZF	DART AEROSPACE LTD	
DRAWN	ZF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	DRAWING NO.	REV. A
MFG. APPR.	DD	D5810	SHEET 7 OF 7
APPROVED	NO	TITLE	SCALE
DE APPR.	CP	XL BASKET BODY	NTS
DATE	20.01.20	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

Purchase Order Receipt Listing

Page 1 of 2

Monday, March 13, 2017 8:40:22 AM

All amounts are calculated in domestic currency.

All Vendors PO ID PO35495 Receipt Dates from 3/10/2017 to 3/10/2017 All Line Item Types

All Item ID/GL/WOs All Rec. Employees All Currencies

Grouped by Vendor ID

Purchase Order ID/ Curr Type	Line Nbr/ Insp Req	Project ID	Reference/ Description/ Cert Std	PO U/M / Stock U/M	Required Date Required Qty	Recv Date/ Recv Emp	Recv Qty (PO U/M)	Cost Per Unit/ Recv Value	Inspected Qty/ Rejected Qty (PO U/M)	MRB Qty/ MRB Reject Qty	Book Amt
VendorID/Vendor Name VC-CAM002 Acier Ouellette Inc.											
PO35495	1		M1010S18GA	sf	3/10/2017	3/10/2017	32.0000	\$1.13	0.0000	0	\$36.14
CAD	No		1010/1/25 SHEET	sf	32.0000	PLOU01		\$36.14	0.0000	0	
			.040								
			m137041								
	2		M2024T3S.040	sf	3/10/2017	3/10/2017	48.0000	\$4.03	0.0000	0	\$193.51
	No		2024-T3 .040 sheet	sf	48.0000	PLOU01		\$193.51	0.0000	0	
			m137041								
	3		M303R0.750	f	3/10/2017	3/10/2017	12.0000	\$3.26	0.0000	0	\$39.08
	No		303 Round Bar 0.750 f	f	12.0000	PLOU01		\$39.08	0.0000	0	
			m137041								
	4		M304S20GA	sf	3/10/2017	3/10/2017	64.0000	\$2.94	0.0000	0	\$188.36
	No		304/316 .040 Sheet	sf	64.0000	PLOU01		\$188.36	0.0000	0	
			m137041								
	5		M606T6S.063	sf	3/10/2017	3/10/2017	64.0000	\$2.35	0.0000	0	\$150.22
	No		606-T6 .063 Sheet	sf	64.0000	PLOU01		\$150.22	0.0000	0	
			m137041								
	6		M606T6S.188	sf	3/10/2017	3/10/2017	32.0000	\$7.40	0.0000	0	\$236.76
	No		606-T6 .188 Sheet	sf	32.0000	PLOU01		\$236.76	0.0000	0	
			m137041								
	7		M7075T73R1.000	f	3/10/2017	3/10/2017	12.0000	\$6.59	0.0000	0	\$79.07
	No		7075-T73 Rd Bar 1.00 f	f	12.0000	PLOU01		\$79.07	0.0000	0	
			m137041								
	8		71550-15	Each	3/10/2017	3/10/2017	1.0000	\$35.29	0.0000	0	\$35.29
	No		TUBE HSS 3 X 3 X		1.0000	PLOU01		\$35.29	0.0000	0	
			0.188" (8 FT)								
			m137041								
	9		71550-15	Each	3/10/2017	3/10/2017	1.0000	\$271.08	0.0000	0	\$271.08
	No		6061-16 BAR 2-1/2"		1.0000	PLOU01		\$271.08	0.0000	0	
			X 6" (5 FT)								
			m137041								

**ACIER OUELLETTE INC.**

935, Boul. du Havre
Salaberry de Valleyfield (Québec) J6S 5L1
Tél.: 450-377-4248 Mtl: 514-336-4248 Ext.: 800-667-4248
Fax: 450-377-5696 Mtl: 514-336-4246 Ext.: 866-456-4242

Order - Sales**Copy**

CO00018604

Customer N° CLI0001056
Date 2017/03/06
Delivery date 2017/03/10
Your order N° 35495
Processed by Josianne Bourdon
Salesman
Carrier OUELLETTE VALLEYFIELD
Credit Terme NET 30
Page 1

Billed to

DART AEROSPACE LTD
1270, ABERDEEN ST.
HAWKESBURY, Ontario, K6A 1K7

Shipped to

DART AEROSPACE LTD

, Ontario,

Att : CHANTAL LAVOIE Tél.: 613-632-5200

Delivery Route 5

Product Description	Weight	Qty	U/M	PCS RE			Internal Use Only				
				CMD	EXP	B/O	IN	I	S	C	OUT
1 CR SHEET 18G (4 X 8) FEER-18G48 3280 1 X 4' X 8' HEAT: 162A03655	64.00	32.00	PI2_\$CLB	1.00							
2 ALU SHEET .040 (18G) 2024-T3 4B (4 X 12) FEAL-0404122024B 3118 1 X 4' X 12' HEAT: 187B4388	27.02	48.00	PI2_\$CLB	1.00							
3 ROUND SS 3/4 303 (12R) RSS-34303-12 5750 1 X 12' 2/L HEAT: W4B3	18.02	12.00	PI_\$CLB	1.00							
4 SHEET SS 20G SL 304-2B (4 X 8) FESS-20G483042B 3430 2 X 4' X 8' HEAT: 825678	100.48	64.00	PI2_\$CLB	2.00							

Next Page...

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: 1010SS-A

PO / BATCH NO.: 25155495/131041

DATE: 11/23/16

MATERIAL CERT REC'D: YES

THICKNESS ORDERED: .048

QUANTITY RECEIVED: 32

THICKNESS RECEIVED: .046

QUANTITY INSPECTED: 32

SHEET SIZE ORDERED: 42X

QUANTITY REJECTED: 0

SHEET SIZE RECEIVED: 42X

DESCRIPTION	NCR (Check Y/N)		COMMENTS
SURFACE DAMAGE	Y	N	
CORRECT FINISH	Y	N	
CORROSION	Y	N	
CORRECT GRAIN DIRECTION	Y	N	
CORRECT MATERIAL	Y	N	CP 1010
CORRECT THICKNESS	Y	N	.046
PHOTO REQUIRED	Y	N	
CORRECT MATERIAL	Y	N	1010-A 1008
CORRECT REF # TO LINK CERT	Y	N	Head # 162AC3655
CORRECT MATERIAL IDENTIFICATION	Y	N	1010SS-A
CORRECT M# ON THE MATERIAL	Y	N	113704
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y	N	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y	N	

CUT SAMPLE PIECE OF MATERIAL AND PERFORM A HARDNESS CHECK. RECORD RESULTS BELOW				
TYPE OF MATERIAL	HRC	HRB	DUR A	DUR D
SIZE OF TEST SAMPLE				
HARDNESS / DUROMETER READING				

testers located in the Quality Office

QC 18 INSPECTION		ENGINEERING SIGNOFF (if required)	
INSPECTED BY: <u>48</u>	SIGNED OFF BY: _____		
DATE: <u>11/23/16</u>	DATE: _____		

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in



“首钢”牌产品质量证明书
QUALITY CERTIFICATE OF “SHOUGANG” BRAND

MANUFACTURED BY: SHONGANG GROUP, SHONGANG, XIOTANG UNITED RCM, LTER, CO., LTD.

营销中心地址: 中国北京市石景山区
 ADD. OF SALESING GROUP: SHIJIINGSHAN DISTRICT, BEIJING, CHINA
 邮政编码: POST CODE: 100041
 电话TEL.: (+8610) 68281603
 或请发送邮件至: E-MAIL: SGTS@MAIL.SGTSING.COM.CN
 新厂地址: 中国北京市昌平区南口工业园区 035200
 ADD. OF NEW FACTORY: CHANGYUJIN INDUSTRIAL PARK, ZHANGSUAN,
 BEIJING, P.R. CHINA 035200

[illegible]

C 650 306
C 650 315

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/>	DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Cross tube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> </div> <div> Eng. (Non-AW) <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Water Jet <input type="checkbox"/> Supplier <input type="checkbox"/> Quality <input type="checkbox"/> </div> </div>			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause <div style="display: flex; flex-direction: column;"> <div>Operator <input type="checkbox"/></div> <div>Manufacturing Process <input type="checkbox"/></div> <div>Equip/Tooling <input type="checkbox"/></div> <div>Handling/Preservation <input type="checkbox"/></div> <div>Material <input type="checkbox"/></div> <div>Product Improvement <input type="checkbox"/></div> <div>Process Improvement <input type="checkbox"/></div> <div>Human Factors <input type="checkbox"/></div> </div>		FAULT CATEGORY <div style="display: flex; flex-wrap: wrap;"> <div style="width: 50%;"> <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Bending <input type="checkbox"/> Crushing <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Mislabeled </div> <div style="width: 50%;"> <input type="checkbox"/> Contamination <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Incomplete/Unclear Instructions <input type="checkbox"/> Drill Holes <input type="checkbox"/> Fit/Function </div> <div style="width: 50%;"> <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain Direction <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Off-set/Set-up </div> <div style="width: 50%;"> <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Outside Tolerance <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Misread </div> </div>			
Other/Details:					